

Date: Thursday, 16/04/2009 1:43:03 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 47247		
Estimate Number	: 10530		
P.O. Number	:	Part Number	: D2571
This Issue	: 16/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2571 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 46952	Drawing Revision	: E
Written By	:	Material	:
Checked & Approved By	: <u>Julie Dawson</u>	Due Date	: 23/04/2009
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: 46412

SL 09/04/19 (6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No: 47247 Double check by: ms

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

ms 09/04/21 SL (6)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

ms 09/04/21 SL (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ms 09/04/21 SL (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

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Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 04/04/22

(6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

gl

09-04-23

(x6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110934

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15
320°
8:45

BR 09-04-24

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

gl

09-04-24

(x6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST433

JS 09/04/24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

Job Completion



mf 09-04-24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47247
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.006		
F	0.490	0.510		.504	.510	.505	.505		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.501	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.568	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.124	.124	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.250	.251		
S	0.115	0.135		.131	.126	.127	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.241	.242	.240		
W	0.115	0.135		.129	.127	.126	.128		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.365	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.630	.630	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.243		
AE	1.375	1.395		1.390	1.391	1.391	1.393		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.247	.247	.248		
AI	2.000	2.020		2.003	2.003	2.003	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	J.L.
Date:	09/04/19

Audited by:	inf
Date:	09/04/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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E	7.990	8.010		8.005	8.005				
F	0.490	0.510		.504	.505				
G	0.257	0.262		.260	.260				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.497	.498				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.567	.565				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.496	1.497				
N	2.495	2.505		2.502	2.502				
O	3.869	3.879		3.873	3.873				
P	0.115	0.135		.126	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.130	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.958	2.958				
V	0.230	0.250		.242	.241				
W	0.115	0.135		.126	.123				
X	0.308	0.313		.310	.309				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.366	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.633	.631				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.390	1.390				
AF	0.115	0.135		.128	.120				
AG	0.240	0.280		.264	.269				
AH	0.240	0.260		.247	.247				
AI	2.000	2.020		2.003	2.006				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>mwf</i>
Date: 09/04/21

Audited by: <i>mwf</i>
Date: 09/04/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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RELEASED

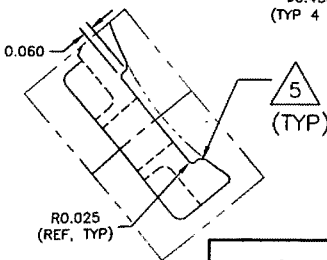
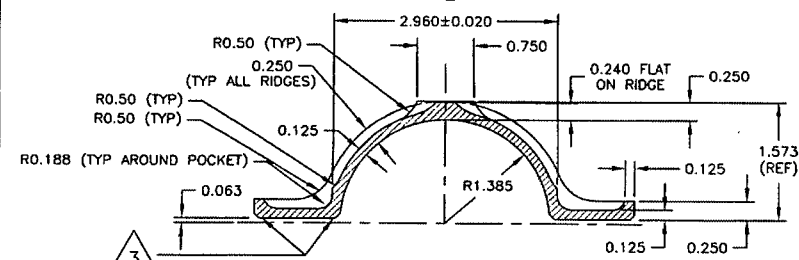
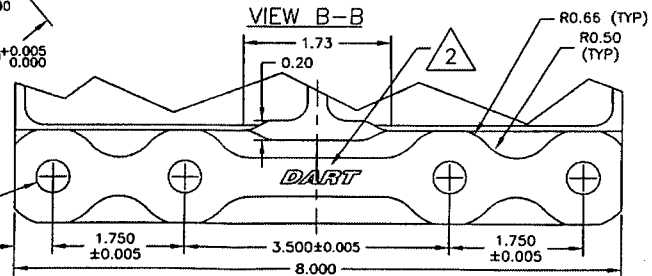
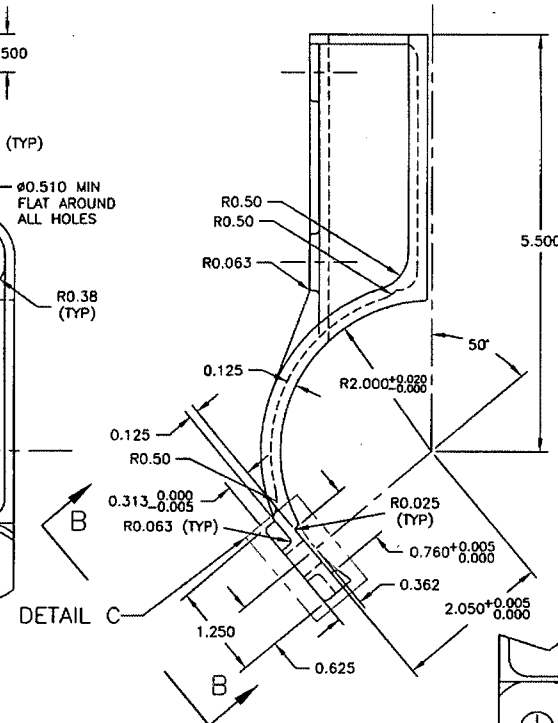
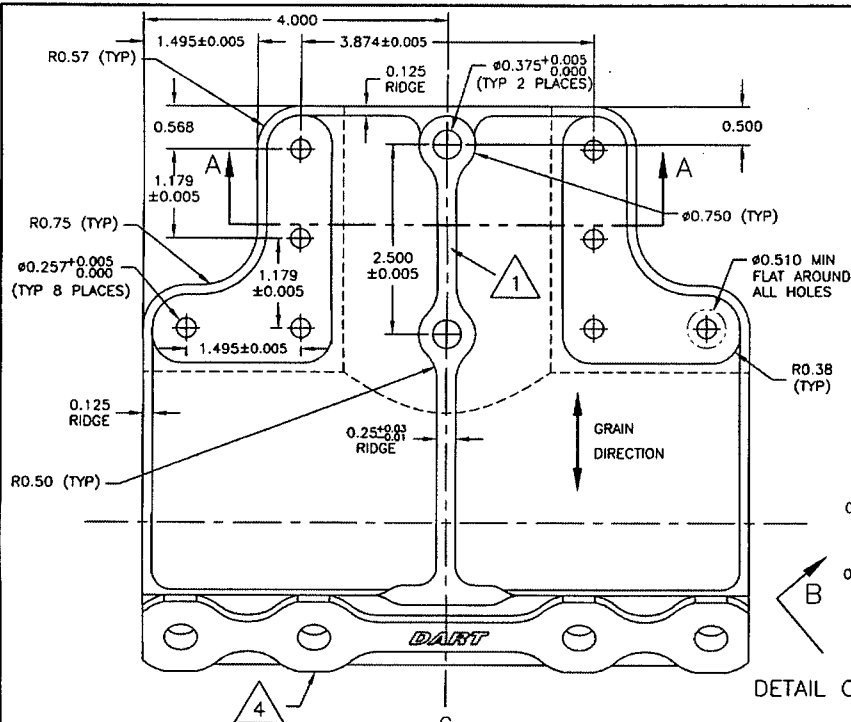
05.12.13

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E



DETAIL C
 SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

NO. 17247
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

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DART DART AEROSPACE LTD.
 MARKHAM, ONTARIO, CANADA

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